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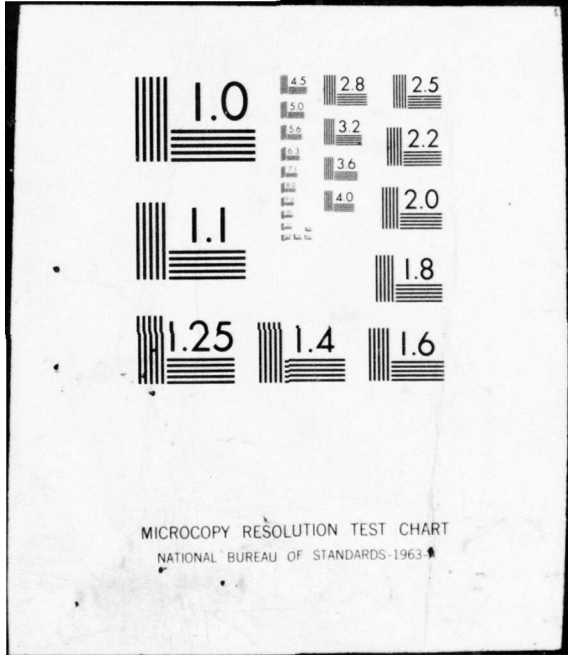
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✓ Contract N00014-76-C-0408

Project NR 092-555

Annual Technical Report

THE ROLE OF CHEMICAL BONDING IN ADHESION

A. N. Gent and P. Dreyfuss

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The University of Akron
Akron, Ohio 44325

November, 1977

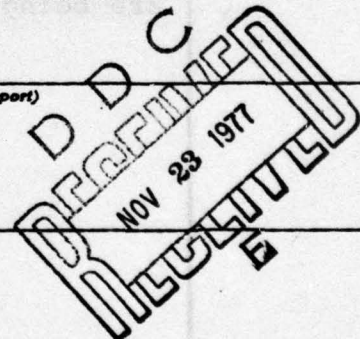
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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM	
1. REPORT NUMBER Annual Technical Report 2	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER (9)	
4. TITLE (and Subtitle) (6) <u>The Role of Chemical Bonding in Adhesion</u>		5. TYPE OF REPORT & PERIOD COVERED Annual Technical Report	
7. AUTHOR(s) (10) <u>A. N. Gent, P. Dreyfuss and M. L. Runge</u>		8. CONTRACT OR GRANT NUMBER(s) (15) <u>NO0014-76-C-0408</u>	
9. PERFORMING ORGANIZATION NAME AND ADDRESS Institute of Polymer Science The University of Akron Akron, Ohio 44325		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS NR 092-555	
11. CONTROLLING OFFICE NAME AND ADDRESS Office of Naval Research Power Program Arlington, Virginia 22217 (11) 21		12. REPORT DATE November 1977	
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office) (14) MR-2 (12) 22p.		13. NUMBER OF PAGES 18	
		15. SECURITY CLASS. (of this report) Unclassified	
16. DISTRIBUTION STATEMENT (of this Report) Approved for public release; distribution unlimited		15a. DECLASSIFICATION/DOWNGRADING SCHEDULE	
17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)			
18. SUPPLEMENTARY NOTES			
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Adhesion, Bonding, Elastomers, Polybutadiene, Glass, Polyphenylene Oxide, Polysulfone, Polycarbonate, Inorganic Salts			
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) Strong positive effects have been found when a polybutadiene layer is adhered to a glass substrate by means of interfacial chemical bonds. The bond fracture energy increased by a factor of over 20 when a reactive polysiloxane coating was applied to the glass in comparison with a similar, but non-reactive, polysiloxane coating and the chemically-bonded layer failed cohesively instead of interfacially. Swelling stresses			

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were found to discriminate between strongly bonded systems of this type. After a swelling period in pentane ranging from 10 minutes to over 72 hours, depending upon the proportion of chemical bonding introduced, the layer detached spontaneously. This suggests a possible test method for distinguishing between bonded systems which would normally all fail by cohesive rupture. Treatment of glass substrates with a monofunctional polybutadiene containing a dimethylmethoxysilane endgroup led to no significant improvement in adhesion. SEM Studies showed that less than 5 percent of the surface was covered by the monofunctional material. Thus it appears that the number of reactive sites per molecule is an important factor governing elastomer adhesion.

An unexpectedly-high level of adhesion was observed between simple hydrocarbon elastomers and certain polymeric substrates: 2,6-dimethyl-1,4-polyphenylene oxide, polysulfone, and polycarbonate. The bond fracture energy was more than six times larger than for other polymeric substrates, e.g., polystyrene and polyethyleneterephthalate. In contrast, the strength of adhesion of polybutadiene to various inorganic crystalline substrates was found to be relatively low in all cases, although different results were obtained for different substrates. For example, adhesion to CaCO_3 , $(\text{NH}_4)_2\text{SO}_4$, and CaF_2 was some 6 to 12 times greater than to NaCl , KCl , or KBr . These measurements are being continued.

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Summary

Strong positive effects have been found when a polybutadiene layer is adhered to a glass substrate by means of interfacial chemical bonds. The bond fracture energy increased by a factor of over 20 when a reactive polysiloxane coating was applied to the glass in comparison with a similar, but non-reactive, polysiloxane coating and the chemically-bonded layer failed cohesively instead of interfacially. Swelling stresses were found to discriminate between strongly bonded systems of this type. After a swelling period in pentane ranging from 10 minutes to over 72 hours, depending upon the proportion of chemical bonding introduced, the layer detached spontaneously. This suggests a possible test method for distinguishing between bonded systems which would normally all fail by cohesive rupture. Treatment of glass substrates with a monofunctional polybutadiene containing a dimethylmethoxysilane endgroup led to no significant improvement in adhesion. SEM studies showed that less than 5 percent of the surface was covered by the monofunctional material. Thus it appears that the number of reactive sites per molecule is an important factor governing elastomer adhesion.

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Introduction

It is generally thought that adhesion is improved by forming chemical bonds between the adherends. For example, coupling agents or adhesion promoters with dual functionality are widely employed to join two materials. However, the real nature of the interface and the extent of chemical coupling achieved is generally rather uncertain. Indeed, it has been questioned whether interfacial chemical bonds are formed at all, and whether they are necessary to obtain a strong joint. Even if some bonding is beneficial, it has been suggested that too high a density of interfacial bonds will make the joint brittle and weak. These questions are discussed more fully in recent reviews by Erickson (1), Kaelble (2), and Cassidy and Yager (3). They explain why a fundamental study of the relation between chemical bonding and adhesion is necessary if further progress is to be made in the science and technology of adhesion.

Existing knowledge about the effect of chemical bonding on adhesive strength is deficient in two ways. First, the existence of chemical bonds in most systems has been inferred rather than demonstrated directly and, second, there has been no direct measurement of the number of bonds formed. Progress

towards such information is summarized in this report. Attention is also drawn to some anomalous results obtained with certain plastic and crystalline substrates which call for further study.

Studies Using Glass Substrates

A monofunctional polybutadiene has been prepared having a number average molecular weight of 150,000 and a dimethylmethoxysilane endgroup. Evidence for the presence of the endgroup includes the following: a) a model reaction with triethylsilanol under conditions previously established for formation of siloxanes from trimethylmethoxysilane led to the expected and immediate formation of methanol, b) the molecular weight doubled under coupling conditions, and, c) this polybutadiene was found to react with glass surfaces, forming widely-separated discrete particles somewhat larger in size than molecular dimensions. The bonded polybutadiene is apparently so incompatible with glass that it coalesces into particles rather than spreads over the surface.



When the work of detachment was measured for a layer of polybutadiene (Diene 35 NFA, Firestone Tire and Rubber Company), crosslinked in contact with the treated glass slide, no difference was found between the peel strength for the treated

slide and a control sample, within experimental error. All samples failed interfacially at about the same low peel force, about 5 N/m. This is probably because the crosslinked polybutadiene overlayer was attached to the glass substrate only via the silanated polybutadiene, i.e., only infrequently, and thus the strength of adhesion was not significantly increased in comparison with a control sample.

In contrast, when chemical bonds were formed between a p-bromomethylphenylpolysiloxane-coated glass slide and a dicarboxyterminated liquid polybutadiene (CTB, B.F. Goodrich Company), a continuous layer of rubber was observed by scanning electron microscopy, rather than discrete rubber particles. (Standard procedures for coupling amino acids to chloromethylated supports in solid peptide synthesis were used to form the bond (4-7)). In addition, as shown in Table I, a marked increase in the work of detachment W was noted when compared to untreated clean slides or slides coated with p-tolylpolysiloxane. The latter in fact gave lower values of W than the clean slides, which suggests that the siloxane coating is functioning as a release agent. The last column in Table I shows that W and

Table I

Effect of *p*-Bromomethylphenylpolysiloxane and *p*-Tolylpolysiloxane Coatings on Work of Adhesion Between Dicarboxyterminated Polybutadiene and Glass and on Time for Bond Failure in Pentane

<u>% of silane in Coating Solution</u>		<u>W(J/m²)^a</u>	<u>Time for Bond Failure in Pentane(hrs)</u>
<u>-Si--CH₃</u>	<u>-Si--CH₂ Br</u>		
0	0	34(I)	~0.08
100	0	20(I)	~0.08
50	50	450(C)	~3
0	100	470(C)	> 72

^aDetermined in a 180° peel test with 0.5 cm per min crosshead speed and 0.1% dicumyl peroxide cure of the polybutadiene. I = interfacial failure. C = cohesive failure of the elastomer.

the different degrees of interfacial bonding could also be related to the time for a bond to fail on swelling in pentane. We conclude that in the case of a silanated surface with dicarboxyterminated polybutadiene the compatibility problem is much reduced. It might also be inferred that the number of functional groups per elastomer molecule is an important factor in developing strong adhesion.

Polymeric Substrates

Initial experiments with chlorosulfonated polystyrene substrates also showed a positive effect of chemical bonding on adhesive strength. When chlorosulfonated polystyrene was reacted with amine terminated polybutadiene (ATB, B. F. Goodrich Company) and then a polybutadiene overlayer was applied and crosslinked in situ with 6% lauroyl peroxide, cohesive failure at the rubber-cloth interface occurred at large peel forces. In contrast, untreated polystyrene slides gave a work of adhesion of 85 J/m^2 and showed interfacial failure at the polystyrene-rubber interface. With a sulfur cure the average value was 51 J/m^2 with interfacial failure at the rubber-rubber interface for the chlorosulfonated slides, compared to only 9 J/m^2 with interfacial failure at the polystyrene-rubber

interface for untreated polystyrene. However, compared to glass substrates polystyrene has several serious disadvantages from an experimental standpoint: (i) the low T_g , $\sim 95^\circ\text{C}$, restricts the choice of peroxide and cure temperature and prevents use of our preferred curing agent, dicumyl peroxide (which reacts at 150°C), (2) nonuniform functionalization was found to occur for many reactions carried out with vaporized reactants, (3) solvents used for application of the functionalized elastomer either dissolved or crazed the polystyrene slides.

Attempts to use substrates with higher values of T_g led to the unexpected discovery of three substrates (adherends) which showed high adhesion to simple elastomers under conditions where weak bonds would be anticipated; namely, low testing rates, moderate temperatures, and with the elastomer layer lightly crosslinked to prevent liquidlike flow (8). The data are presented in Table II along with typical results for other substrates taken from the literature and some new results with a polystyrene substrate.

The adhesion of the elastomers used here to poly-2,6-dimethyl-1,4-phenylene-oxide (PPO), polysulfone, and polycarbonate is surprisingly high. With these substrates cohesive failure of the elastomer occurred at high peel forces, whereas with other substrates interfacial failure was observed at low

Table II

Effect of Substrate on Adhesion^a

Substrate	Elastomer ^b	Work of Adhesion(J/m ²) ^c		Ref
		50 cpm	25 cpm	
Polyethylene terephthalate ^d	SBR ^e	-	32(I)	9
	Dicup(1)	-	5(I)	
	EPR ^f	-	176(I)	9
Aluminum	SBR ^e	-	609(I)	10
	Dicup(1)	-	38(I)	
	Polybutadiene ^h	-	590(I)	10
Pyrex Glass ^g	Dicup(0.05)	-	-	
	Dicup(0.2)	-	-	
	Polybutadiene ^h	-	-	
Quartz	Dicup(0.05)	-	-	
	Polybutadiene ^h	-	-	
	Lauroyl Peroxide(6.39)	129(I)	-	j
Polystyrene ⁱ	Sulfur ^k	11(I)	-	j
	EPR ^l	120-300(I)	-	9
	SBR ^m	-	-	
	Lauroyl Peroxide(6)	150(I)	-	
	Polybutadiene ^h	-	-	
	Lauroyl Peroxide(10)	~ 500(c)	-	j
	Dicup(0.1-1)	~ 460(c)	-	
	Sulfur ^k	76(I)	-	
	EPR ^l	1200-1660(I)	-	
	SBR ^m	> 1000(c)	-	
PPO ⁿ	Lauroyl Peroxide(6)	~ 500(c)	-	
	Polybutadiene ^h	~ 500(c)	-	j
Polycarbonate ^o	Lauroyl Peroxide(6)	~ 480(c)	-	j
	Dicup(0.1)	~ 460(c)	-	
Polysulfone ^p	Lauroyl Peroxide(6)	~ 480(c)	-	j
	Dicup(0.1)	~ 460(c)	-	

Footnotes to Table II

- ^a Peel tests at 180° were carried out as previously described (8).
- ^b The curing agents and the percent of each are listed under the elastomer. Procedures for curing varied and are described for specific elastomer-substrate pairs.
- ^c Two speeds are given because literature data are not available at 50 cpm, where our data is most complete. We tested our samples at a variety of crosshead speeds from 0.05 cpm to 50 cpm. When cohesive failure (C) occurred at 50 cpm, it occurred at all speeds used. The differences between 50 cpm and 20 cpm were slight. I = predominantly interfacial failure. cpm = cm per min.
- ^d Mylar, Type A (E.I. du Pont de Nemours and Co.).
- ^e Ameripol 1513 (Goodrich-Gulf Chemicals, Inc.)-A 60/40: butadiene/styrene cold emulsion SBR rubber. Cured samples were prepared by swelling 1 phr Dicumyl and 1 phr PBNA from diethyl ether into a thin sheet of rubber, drying, and curing after bond formation for 30 min. at 150°C. Dicumyl=dicumyl peroxide. PBNA = phenyl-β-naphthylamine.
- ^f Vistalon 404 (Enjay Chemical Co.).
- ^g 7740 Glass (Corning Glass Works).
- ^h Diene 35 NFA (Firestone Tire and Rubber Co.)-An anionically polymerized polybutadiene rubber. Cured samples were prepared by mixing with variable amounts of peroxide on an open mill and curing after bond formation. With Dicumyl cures were carried out for 2 hrs. at 150°C. With lauroyl peroxide 6 hrs. at 85°C was used.
- ⁱ Styron 678 (Dow Chemical Co.).
- ^j This work.

Footnotes to Table II(contd.)

^k Cured samples were prepared by mixing on an open mill and curing after bonding for 9 hrs. at 65°C. The recipe contained 100 parts polybutadiene, 12 parts Butyl Eight, 1.5 parts Altax, 1.5 parts sulfur, 3 parts zinc oxide, and 0.5 parts stearic acid. Interfacial failure in these cases may be due to the presence of sulfur at the interface.

^l EPR 404 (Enjay Chemical Co.)

^m Ameripol 1502 (Goodrich-Gulf Chemicals, Inc.)-A 76.5/23.5: butadiene/styrene cold emulsion SBR rubber; cured after bond formation for 6 hrs. at 85°C.

ⁿ (General Electric Co.)

^o (Cadillac Plastic and Chemical Co.)

^p (Scientific Polymer Products, Inc.)

peel forces. Even in the two cases where cohesive failure was not observed, EPR-PPO, the work of adhesion was more than six times the work of adhesion for a similar EPR-polystyrene specimen. Such strong adhesion to certain plastics could clearly be of technological importance.

The reason for this strong adhesion is at present obscure. Possibilities include good compatibility between the resins and polybutadiene, chemical bond formation during the free radical crosslinking reaction of the elastomer layer, and specific electronic interaction such as π - π orbital overlap between the unsaturated elastomer layer and the electron-rich backbones (11). Differences in compatibility as proposed by Iyengar and Erickson (12) seem unlikely to be responsible for the observed effects because polystyrene and PPO have very similar solubility parameters (13-15) and yet behave very differently in adhesion studies. Further experiments are planned to investigate the mechanism of this anomalously-high adhesion.

Crystalline Substrates

Adhesion between polymers and crystalline substances is not well understood (16) but it is very important technologically, especially in the preparation of solid propellant fuels

where a crystalline oxidizer is embedded in a rubber matrix (17). A fundamental investigation of the adhesion of polybutadiene to model crystalline substrates has therefore been initiated. Detachment energy is determined in 90° peel tests using an apparatus consisting of a sensitive force-gauge mounted on an Instron Tester with the output exhibited on a recording oscilloscope. Freshly cleaved crystal surfaces were generally used, although a few experiments were done with polished surfaces.

Considerable variation was found in the strength of the adhesive bond between polybutadiene and different crystalline substrates, as shown in Figure 1. The general level of adhesion was relatively small, however. The crystals examined so far include cubic KBr, KCl, NaCl and CaF_2 , hexagonal CaCO_3 , and rhombic $(\text{NH}_4)_2\text{SO}_4$. The latter is a possible analog of a typical propellant grain, rhombic NH_4ClO_4 , but it is more stable and thus more convenient for exploratory studies of adhesion between an elastomer and a crystalline substrate.

The cubic alkali halides (KBr, KCl, NaCl) showed the lowest levels of adhesion to the polybutadiene elastomer, near zero. A slight increase was observed as the size of the singly charged ions and hence the number of electrons surrounding the nucleus

increased, but the differences were rather small. (The ionic radii are 0.95, 1.33, 1.81, 1.95 Å for Na^+ , K^+ , Cl^- , Br^- , respectively (18)). CaF_2 , which is also cubic but contains a divalent Ca^{2+} cation in addition to the monovalent F^- anion, resulted in 2-3 times the detachment energy of the other cubic crystals examined. $(\text{NH}_4)_2\text{SO}_4$, which is rhombic and has the divalent anion SO_4^{2-} and two monovalent NH_4^+ cations, showed an even higher detachment energy than CaF_2 . Finally, CaCO_3 , which is hexagonal and contains both divalent cations and anions, showed the highest detachment energy of the crystals tested so far. (The ionic radii are 0.99, 1.33, 1.43 Å for Ca^{2+} , F^- , NH_4^+ , respectively. CO_3^{2-} and SO_4^{2-} are nonspherical ions, and ionic radii have no meaning for them.) From these few crystals it appears that ionic charge and size are more important than crystal structure in determining the detachment energy of polybutadiene from inorganic crystals.

Finally, very limited comparisons between cleaved and "polished" surfaces combined with SEM examination of the surfaces indicate that adhesion to microscopically rough surfaces is significantly increased over adhesion to smooth surfaces. More

careful experiments with higher quality freshly cleaved crystals did not confirm some preliminary observations that drying of the crystal surfaces is essential to secure a measurable degree of adhesion. Drying was beneficial only with student crystals of NaCl and naturally occurring calcite (CaCO_3).

In summary, our limited studies with inorganic crystalline substrates indicate that ionic charge, ionic size, and surface roughness of the adherend are important factors determining the detachment energy of a polybutadiene overlayer. Crystallographic structure and electronegativity differences of the anion in the adherend seem to be less important.

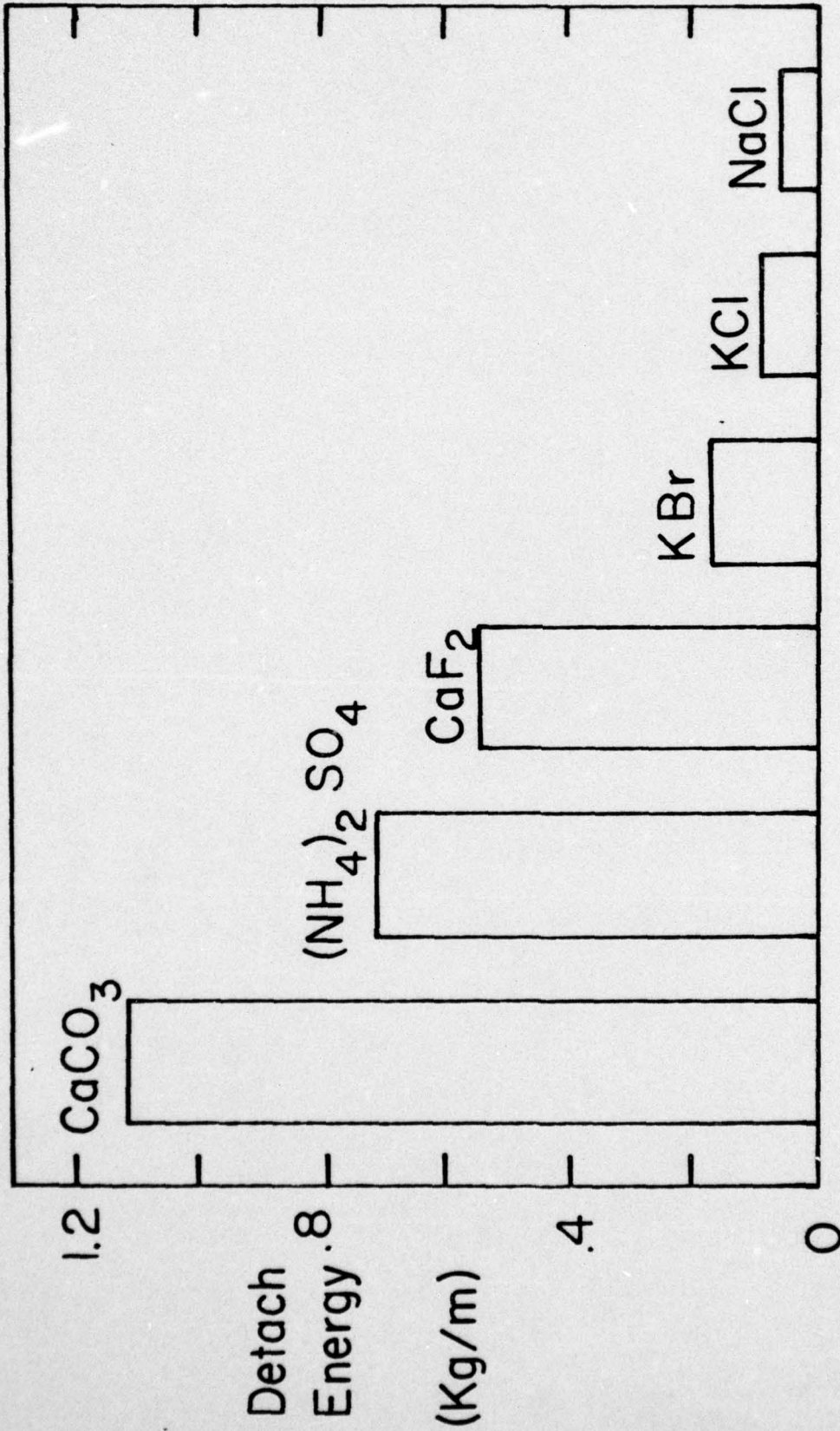
Acknowledgements

Experimental work on this project was carried out at various times by Drs. M. L. Runge and Q. S. Lien, and Messrs. R. J. Chang, E. A. DiCato, N. K. Eib, and P. Marteny. Experimental results supplied by the above persons form part of this report. We also thank K. Riew of the B. F. Goodrich Co. for supplying the samples of CTB and ATB, the Firestone Tire and Rubber Co. for samples of Diene 35NFA, and P. Shank of the General Electric Co. for the sample of PPO.

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Rubber: PBD-35, .06% dicup

Figure 1. Variation in strength of adhesive bond between polybutadiene and different crystalline substrates

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